



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81677****\*81677\***

Page 2

March-16-12 1:58:02 PM

Item ID: D4108-049 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Litter Door Fitting Assembly  
Start Date: 16/03/2012 Start Qty: 6.00 **\*6\*** Cust Item ID:  
Required Date: 22/03/2012 Req'd Qty: 6.00 **\*6\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

12/11/59 J  
MCS 12-11-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March-16-12 1:58:05 PM

Page 1

Work Order ID: 81677

**\*81677\***

Parent Item: D4108-049

**\*D4108-049\***

Parent Item Name: Litter Door Fitting Assembly

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD IPP  
Rev:B 10.12.03 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3622-1

Manufactured

No

110

Each

50.0000

1

6

**\*D3622-1\***

Ball Stud

\*\*

FF 12-11-01

Location

ST058

87640

80533

78837

80405

Loc Qty

50

30

20

Loc Code

2

4

NAS1149C0532R

Purchased

No

110

Each

485.0000

2

12

**\*NAS1149C0532R\***

WASHER

\*\*

FF 12-11-01

Location

ST297

122441

116373

116513

118384

119736

Loc Qty

485

1

53

31

400

Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March-16-12 1:58:06 PM

Page 2

Work Order ID: 81677

**\*81677\***

Parent Item: D4108-049

**\*D4108-049\***

Parent Item Name: Litter Door Fitting Assembly

Start Date: 16/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

MS21043-5

Purchased

No

110

Each

499.0000

1

6

**\*MS21043-5\***

Nut

\*\*

FF 12-11-01

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

54

112314

54

ST301

425

116548

100

118159

100

119307

25

119537

200

6

D4108-9

Manufactured

No

110

Each

1.0000

1

6

**\*D4108-9\***

Fitting, Litter Door

\*\*

FF 12-11-01

Location

Loc Qty

Loc Code

st128

B84009

1

64805

1

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

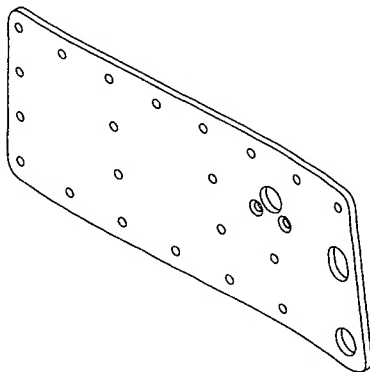
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

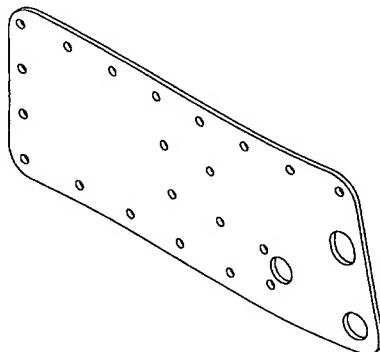
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

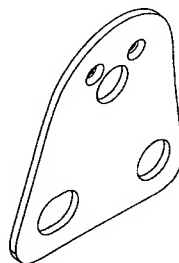




**D4108-1 LEFT PASS DOOR DOUBLER**



**D4108-3 RIGHT PASS DOOR DOUBLER**



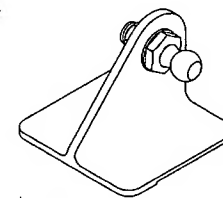
**D4108-5 SMALL RIGHT DOOR DOUBLER**



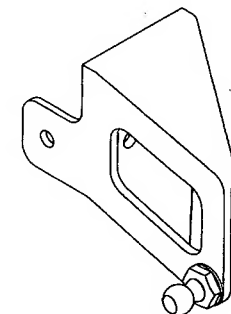
**D4108-11 TEMPLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81677 MCT

12/03/16



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-049 LITTER DOOR FITTING ASSEMBLY**

**RELEASED**  
2010-11-30

B	D4108-5 (ZN C4-1 & B4-4) VIEWS UPDATED. D4108-7/-9 MTL CHANGED TO 8081-T8 AL. NOTES UPDATED (SHT 5,8)	JPH	10.11.01
A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4108	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLERS & FITTINGS	NTS
DATE	10.11.01	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

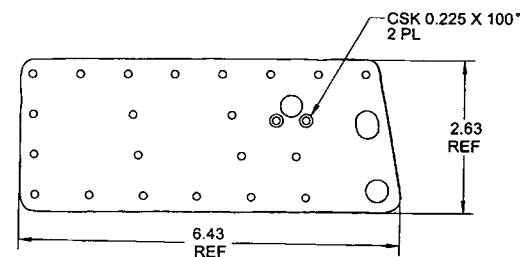
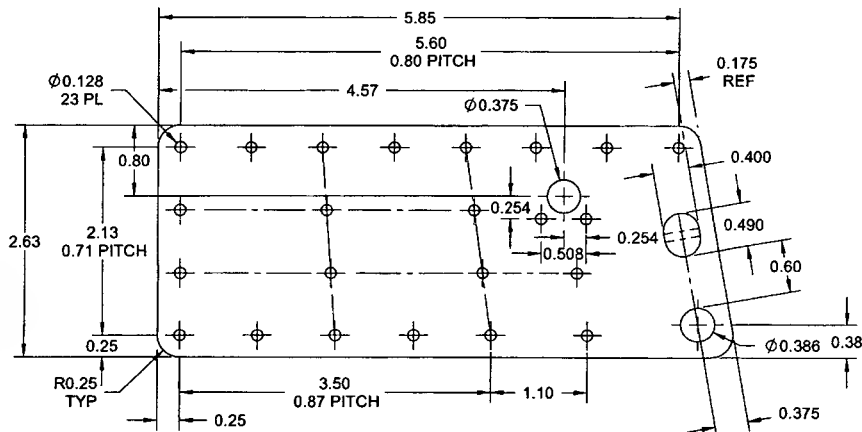
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4108-1F FLAT PATTERN, LEFT PASSENGER DOOR DOUBLER**

NOTES:

1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-1 : MAKE FROM D4108-1F.

2) FINISH: NONE.

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.

4) UNITS: INCHES UNLESS OTHERWISE NOTED.

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: -1: P/N D4108-1 & B/N PER QSI 044 6.1

7) WEIGHT: 0.29 lbs

8) FORM & INSPECTION PER TEMPLATE DT9648.

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

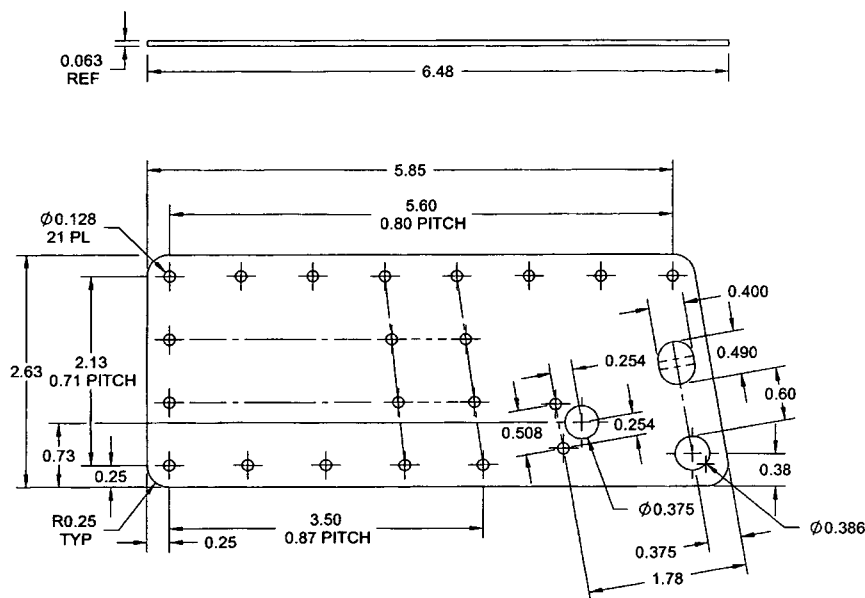
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

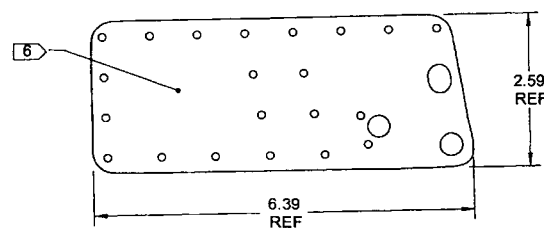
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81677



**D4108-3F FLAT PATTERN, RIGHT PASSENGER DOOR DOUBLER**



**D4108-3 RIGHT PASS DOOR DOUBLER (8)**  
(MAKE FROM D4108-3F)

**NOTES:**

- 1) MATERIAL -3F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA  
-3 : MAKE FROM D4108-3F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -3: P/N D4108-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.29 lbs
- 8) FORM & INSPECTION PER TEMPLATE DT9649.

RELEASED  
2010-11-30

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. <b>D4108</b>	REV. B
MFG. APPR.	JPH	SHEET 3 OF 7	
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

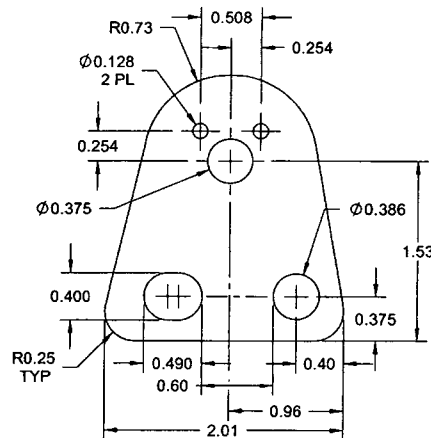
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

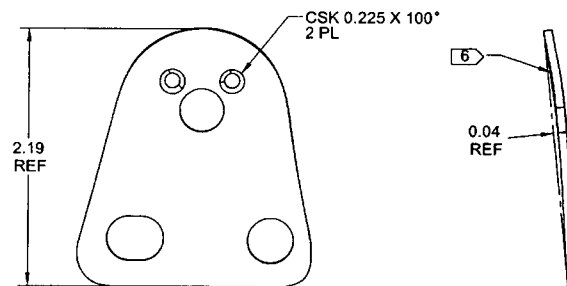
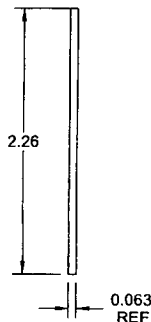
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81677



**D4108-5F FLAT PATTERN, SMALL RIGHT DOOR DOUBLER**



**D4108-5 SMALL RIGHT DOOR DOUBLER (MAKE FROM D4108-5F)**

**NOTES:**

- 1) MATERIAL -5F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
PER DART SPEC M304S16GA OR M303S16GA
- 5: MAKE FROM D4108-5F.
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: -5: P/N D4108-5 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.06 lbs
- 8) FORM & INSPECT PER TEMPLATE DT9849.

RELEASED  
2010-11-30  
ND

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4108</b>	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>DOUBLERS &amp; FITTINGS</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

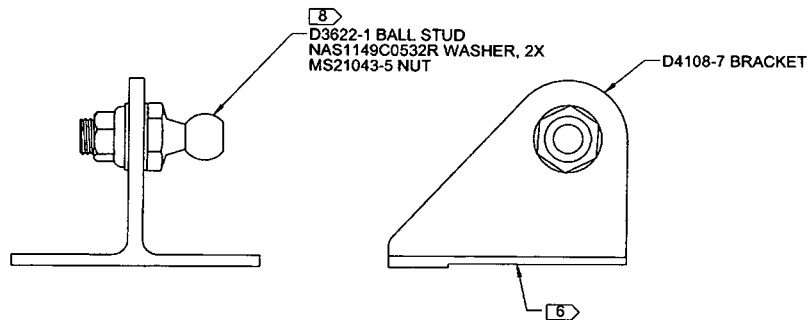
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

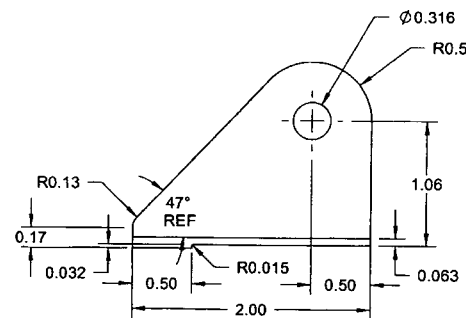
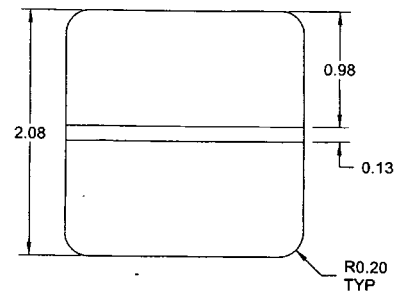
**NOTE:** Date & initial all entries



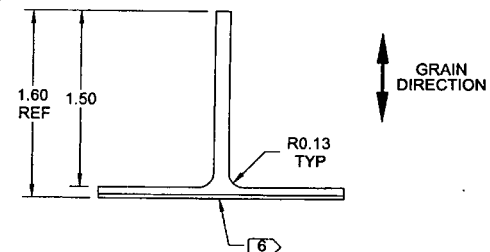
Qty	Part Number	Description
1	D4108-047	SILL BRACKET ASSEMBLY
1	D4108-7	BRACKET
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-7 BRACKET**



- NOTES:**
- 1) MATERIAL -7: 6061-T6/T651/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1.
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -047: 0.10 lbs
  - 8) TORQUE TO 5-10 INCH POUND.

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4108	SHEET 5 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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2010-11-30

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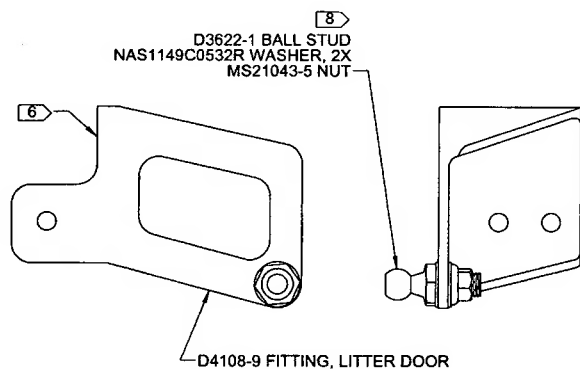
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

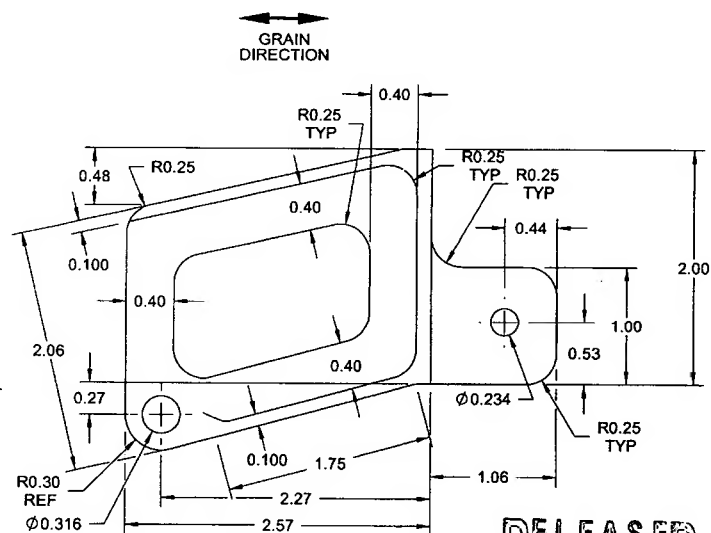
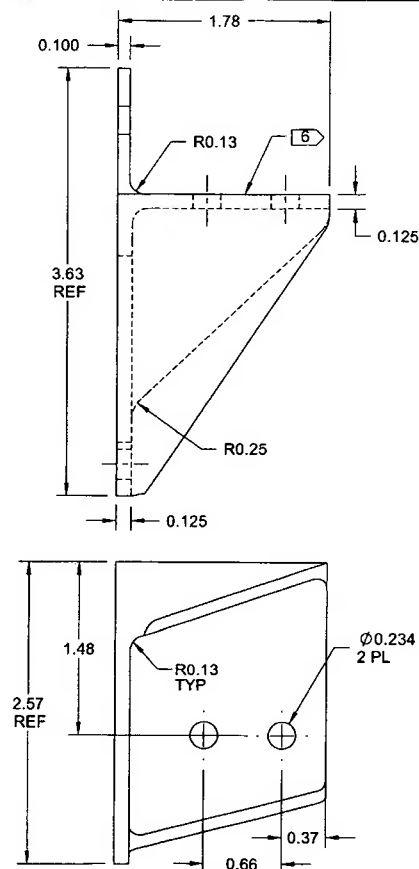
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER




### D4108-049 LITTER DOOR FITTING ASSEMBLY



### D4108-9 FITTING, LITTER DOOR

- NOTES:
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
  - 7) WEIGHT -049: 0.19 lbs
  - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE		10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>

RELEASED  
2010-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

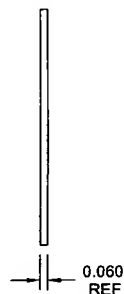
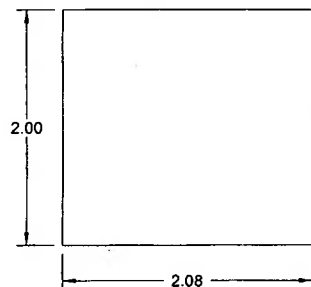
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81677



**D4108-11 TEMPLATE**

RELEASED  
2010-11-30

**NOTES:**

- 1) MATERIAL: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N D4108-11 PER QSI 044 6.1
- 7) WEIGHT: N/A

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4108</b>	REV. B SHEET 7 OF 7
MFG. APPR.	<i>[Signature]</i>	TITLE <b>DOUBLERS &amp; FITTINGS</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.11.01		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries